

Work Order ID 83320

83320

Page 1

Tuesday, April 17, 2012 1:15:37 PM

Item ID: D3414-3 Accept *N900040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Lug
 Start Date: 4/17/2012 Start Qty: 40.00 *40* Cust Item ID:
 Required Date: 4/25/2012 Req'd Qty: 40.00 *40* Customer:
 Reference:

Approvals: Process Plan: Date: 12-04-17 Tooling: Date: Run Start *NR1*
 QC: Date: SPC (Y/N): Date: Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D3414	Rev C								

100 0.00
 100
 Bandsaw Memo 0.00
 Jeaspa Bandsaw Cut blanks: 2.50" x 0.500" x 2.250" long

25 12-04-20 (x40)

110 0.00
 110
 HAAS 1 Memo 0.00
 HAAS CNC vertical machine #1 Machine as per Folio FA569 and Dwg D3414
 Identify as D3414-3Dwg Rev C Folio Rev A4

25 12-04-25 (x40)

120 0.00
 120
 QC QC2- Inspect parts off machine FAI/FAIB 0.00
 Quality Control Memo

25 12-04-25 (x40)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Page 2

Item ID: D3414-3

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Lug

Start Date: 4/17/2012 Start Qty: 40.00

40

Cust Item ID:

Required Date: 4/25/2012 Req'd Qty: 40.00

40

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130

QC8- Inspect parts - second check

0.00

*OK 12/04/25****130***

QC

Memo

0.00

40

Quality Control

140

Identify as per dwg & Stock Location: *W17*

0.00

140

Packaging

Memo

0.00

*40**SD 12-04-26*

Packaging

150

QC21- Final Inspection - Work Order Release

0.00

150

QC

Memo

0.00

12/4/30

Quality Control

12-04-27

W/O:		WORK ORDER CHANGES					
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Picklist Print

Tuesday, April 17, 2012 1:15:41 PM

Page 1

Work Order ID: 83320

83320

Parent Item: D3414-3

D3414-3

Parent Item Name: Lug

Start Date: 4/17/2012

Required Date: 4/25/2012

Start Qty: 40.00

Required Qty: 40.00

Comments: IPP A05.09.13New issueKJ/JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
---------------------------------	------------------------	---------------	-------------	---------------------	------------------	-----------------	--------------------	----------------	-------------	--------------	---------------	----------------	--------

M304B0.500X2.500

Purchased

No

100

f

36.4970

0.1875

7.5

M304B0 500X2 500

**

RS 12-04-20

304 BAR .500 x 2.50

Location

Loc Qty

Loc Code

MAT050

36.497

112764

8.312

116135

0.375

117685

4.4

119231

23.41

59 27

x 7.5

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

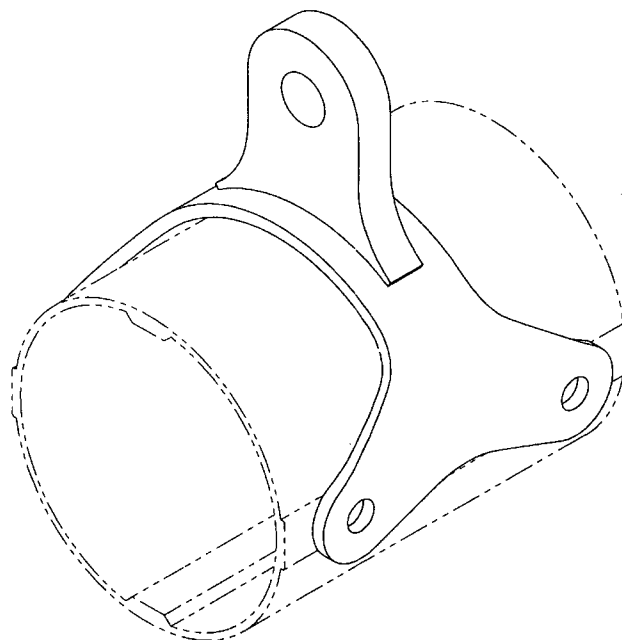
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ITEM No.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D3414-041	LUG ASSEMBLY
2	1	D3414-1	LUG BRACKET
3	1	D3414-3	LUG



D3414-041 LUG ASSEMBLY

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83320

RD1204-17

RELEASED
8/16/05

C	BREAK SHARP EDGES FOR -3 NOW 0.030-0.060 WAS 0.010-0.030 (ZN AT-3)	CP	09.06.17
B	DRAWING REDRAWN IN SOLIDWORKS WITH CURRENT STANDARDS AND TRANSFERRED TO "B" SIZE BORDER. FLAT PATTERN FOR -1 INCREASED IN LENGTH TO PREVENT FOULING AT INSTL (SEE PAR198). FLAT SPOTS REMOVED FROM -1 (PART NOW "U" SHAPED) FOR EASE OF MANUFACTURE. B7-3 ADDED TOLERANCE TO 3.230 DIM. C2-3 1.12 DIM WAS 1.20.	AJS	08.09.23
A	NEW ISSUE	CP	05.03.16
REV.	DESCRIPTION	BY	DATE
DESIGN	CP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	CP		
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>[Signature]</i>	D3414	SHEET 1 OF 3
APPROVED	<i>[Signature]</i>	TITLE	SCALE
DE APPR.	<i>[Signature]</i>	LUG ASSEMBLY	NTS
DATE	09.06.17	<small>COPYRIGHT © 2005 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: POWDER COAT WHITE (4.3.5.2) PER DART QSI 005 4.3
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3414-041" USING FINE POINT PERMANENT INK MARKER
- 7) WEIGHT: 0.52 lbs

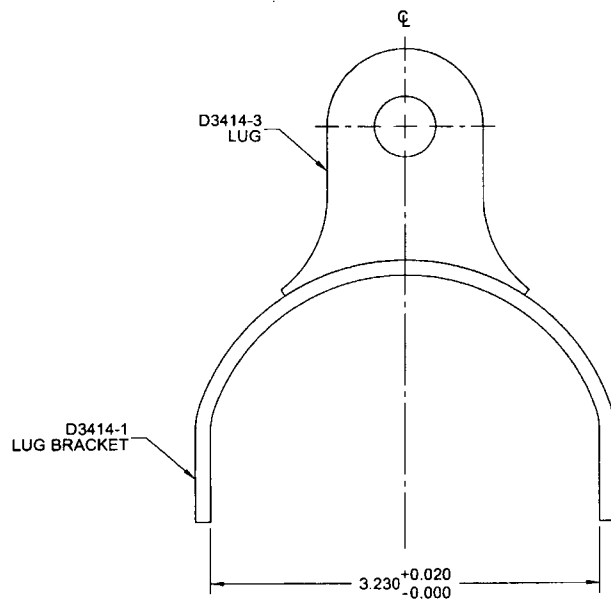
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

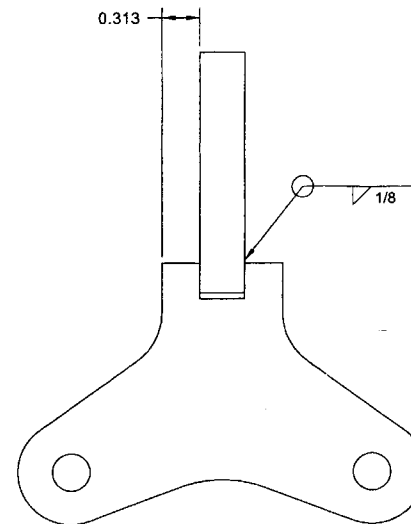
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D3414-041 LUG ASSEMBLY



83320

RELEASED
04/12/15

DESIGN	CP	DART AEROSPACE LTD	
DRAWN	CP	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. D3414	REV. C
MFG. APPR.		SHEET 2 OF 3	
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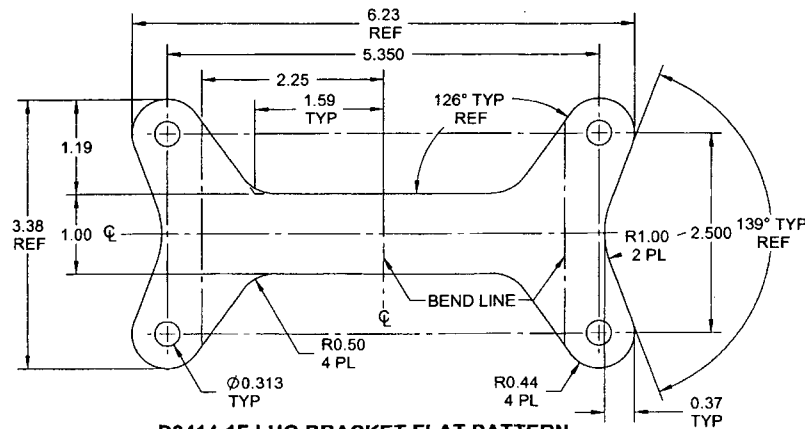
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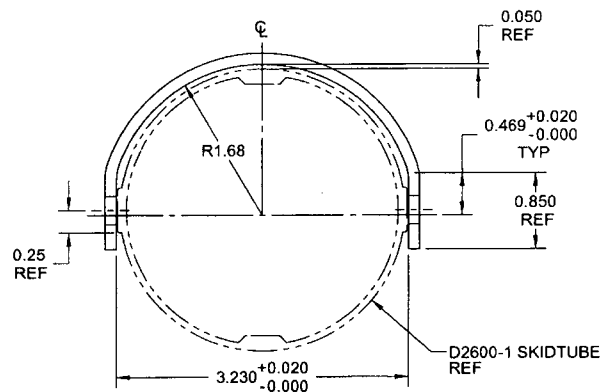
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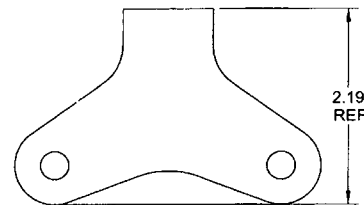
NOTE: Date & initial all entries



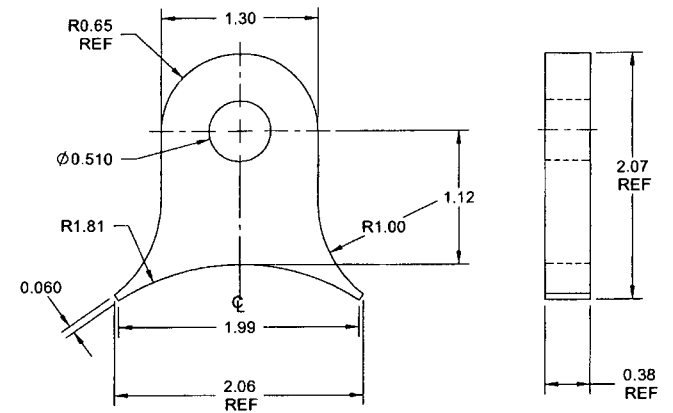
D3414-1F LUG BRACKET FLAT PATTERN



D3414-1 LUG BRACKET



SIDE VIEW FOR REF ONLY



D3414-3 LUG

83320

RELEASED

NOTES

1) MATERIAL: -1: AISI 304/316 STAINLESS STEEL SHEET, 12 GAUGE (0.100 THICK)
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S12GA

-3: AISI 304/316 STAINLESS STEEL PLATE
PER MIL-S-5059 (ANNEALED) 2B FINISH OR AMS 5513/5524
REF. DART SPEC. M304S

2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED

4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: -1: 0.010 TO 0.020 MAX
-3: 0.030 TO 0.060 MAX

6) IDENTIFICATION: N/A
7) WEIGHT: N/A

DESIGN	OP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	OP		
CHECKED		DRAWING NO. D3414	REV. C
MFG. APPR.		TITLE LUG ASSEMBLY	SHEET 3 OF 3
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2005 BY DART AEROSPACE LTD	
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DART AEROSPACE LTD		Work Order:	<i>93320</i>
Description: Lug		Part Number:	D3414-3
Inspection Dwg: D3414 Rev: C		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☒ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø0.510	+0.008/-0.001	<i>.510</i>	✓		<i>snap gauge mic</i>	<i>RT - 1</i>
2.07	+/-0.030	<i>2.07</i>	✓		<i>height gauge</i>	<i>31006</i>
1.99	+/-0.030	<i>1.991</i>	✓		<i>vern</i>	<i>RT - 4</i>
1.30	+/-0.030	<i>1.301</i>	✓		"	"
1.12	+/-0.030	<i>1.12</i>	✓		"	"
0.38	+/-0.030	<i>.375</i>	✓		"	"
0.060	+/-0.010	<i>.063</i>	✓		"	"

Measured by: <i>RS</i>	Audited by: <i>amf</i>	Prototype Approval:	N/A
Date: <i>12-04-24</i>	Date: <i>12/04/25</i>	Date:	N/A

Rev	Date	Change	Revised by	Approved
A	09.09.14	New Issue	KJ	
B	09.11.12	Dwg Rev updated	KJ	<i>[Signature]</i>

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